

Puget Sound Air Pollution Control Agency

110 Union Street, Suite 500,  
Seattle, WA 98101-2038

F A X

June 26, 1998

To: Ash Grove Cement

From: Fred Austin

Attn: Gerry Brown (623-5596)

Phone: 206-689-4055

FAX Number: **623-5355**

FAX: 206-343-7522

Good morning Gerry:

I will be on vacation for a week. Mean-while, Jay likes all that we have done. He feels Appendix A has too much material to be entered into the HP-3000 Equipment Listing.

However, he requested that the heading of Appendix A refer to Notice of Construction No. 7381 and be dated. I also think it might be nice if there was an Ash Grove header. This way the appendix can stand on its own.

Please make these changes and return to Jay, since I'll be gone.

Thanks.

Willenberg

TOTAL PAGES = 1

# ASH GROVE CEMENT COMPANY



"WESTERN REGION"

June 26, 1998

Mr. Jay Willenberg  
Puget Sound Air Pollution Control Agency  
110 Union Street, Suite 500  
Seattle, WA. 98101-2038

Dear Mr. Willenberg:

As per Fred Austin's instructions, attached you will find Appendix A with the following references added to the heading:

1. Ash Grove Cement Co.
2. PSAPCA NOC No. 7381.
3. effective date.

Page numbers have also been included.

Please let me know if you have any further comments.

Yours truly,

Gerald J. Brown  
Manager Safety and Environment

cc: Henrik Voldbaek  
Fred Austin

**ASH GROVE CEMENT CO.**  
**Seattle Plant**  
**Appendix A**  
**PSAPCA NOC No 7381**  
**June 1998**

**KILN START UP/SHUTDOWN and MAINTENANCE PROCEDURES**

**KILN START UP - PREHEATING**

1. Start the main baghouse.
2. Follow the designated preheating guidelines for increasing kiln temperature, decreasing oxygen and for kiln rotation.
3. Adjust the air flow and fuels to increase stage 5 exit temperature and decrease kiln inlet oxygen in accordance with the preheat guidelines.
4. Feed is added to the kiln when the 5<sup>th</sup> stage exit gas temperature is between 1,300 and 1,700 degrees F. Preheat ends with the introduction of feed to the kiln.

**KILN START UP - FEED INTRODUCTION**

1. When the kiln is prepared for feed as per the preheating guideline, start the kiln main drive and assure the ID fan is running at the appropriate speed..
2. After the kiln is on main drive, start the kiln feed at 75 tons per hour with sorbent added as necessary, to control sulfur dioxide emissions to below permit level.
3. Maintain the temperature of the material stream, increase the feed rate and adjust the draft and the fuel to achieve normal production levels.
4. Estimated START UP time: 24 hours following a successful initial feeding of the kiln as defined by #2 above.

**KILN SHUT DOWN**

1. Stop the feed, shut off the fuel and reduce the draft. For emergency shut downs, retain as much heat as possible in the kiln to ease restart after the cause of the emergency is corrected.
2. The kiln is rotated in accordance with the guidelines to prevent thermal warpage of the kiln shell and shock to the refractory that could cause failure of either. During these rotations feed material inside the kiln is discharged. All turns are to be made on the auxiliary drive and should be approximately 100 degrees of rotation.
3. Cooling air flow is adjusted after the fire is taken off the kiln. The temperature must be decreased in a manner protective of the kiln system and refractories.
4. If a situation such as a critical position of the kiln is encountered, heavy rains begin or similar event, the kiln may be rotated continuously for protection of the shell until the situation clears.
5. The baghouse will remain in operation.
6. A cool down period is required before entry is made into the kiln.

**Appendix A**  
**PSAPCA NOC No 7381**  
**June 1998**

**MAIN BAGHOUSE MAINTENANCE PROCEDURES**

**MONITORING PERFORMANCE**

1. Main Baghouse temperatures and pressures in the baghouse are continuously monitored by the control room while performance is checked by an opacity monitor on the kiln stack.
2. Condition of the baghouse components are inspected routinely to prevent failures during operation.

**TROUBLE SHOOTING**

1. Efforts to repair deficiencies will begin immediately upon detection.
2. Once a problem is identified and located, individual compartment(s) containing the defective equipment can be isolated for repairs without shutting down the entire baghouse.
3. Baghouse inlet and blow back dampers are closed and secured to isolate the compartment(s) containing the problem.
4. Compartment(s) doors are opened and the cell is allowed to cool for safe entry.
5. Once the repairs are completed, the compartment(s) is returned to operation.